

Tas little
#4.

Dart Aerospace Ltd.
1270 Aberdeen St
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K6A 1K7
Canada

Tel (613) 632-5200
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D135-1027-103
Job Sheet 190546



Part No: D135-1027-103

Job Qty: 1 pcs

Part Name: MID Height FWD Crosstube



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 2/11/19

Job Tracking No:

Due Date: 3/29/19

Created By: Jesse White

Type: SOLD

Description:

Note: IIN-D135-1027 REV.C IPP REV:A 17.10.24 NEW ISSUE DD VERF:JFS IPP REV:B 18.11.08 AS PER IIN
REV.C DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Packaging 1 - Pick Kit	1 pcs	3/29/19		0.00	0.00	Packaging 1 - 1		
							Packaging 1 - 2		
							Packaging 1 - 3		
							Packaging 1 - 4		
							Packaging 1 - 5		
							Packaging 1 - 6		
							Packaging 1 - 7		
							Packaging 1 - 8		
							Packaging 1 - 9		
							Packaging 1 - 10		
							Packaging 1 - 11		
							Packaging 1 - 12		
							Packaging 1 - 13		DAS
							Packaging 1 - 14		74
							Packaging 1 - 15		9-89
							Packaging 1 - 16		
							Packaging 1 - 17		
							Packaging 1 - 18		
							Packaging 1 - 19		
							Packaging 1 - 20		
							Packaging 1 - 21		
							Packaging 1 - 22		
							Packaging 1 - 23		
							Packaging 1 - 24		
							Packaging 1 - 25		
							Packaging 1 - 26		
							Packaging 1 - 27		
							Packaging 1 - 28		
							Packaging 1 - 29		
							Packaging 1 - 30		



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Container No: S203740



Part: D135-1027-103

Job No: 190546

Serial No/Batch: S203740

Revision: D

Inspector:

Exp Date:

Instructions: TC STC SH18-49 Issue 1, FAA STC SR04276NY dated 18/11/21, EA

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

110 QC 4	1 pcs	3/29/19	0.00 0.00	Packaging 1 - 31	
				Packaging 1 - 32	
				Packaging 1 - 33	
				Packaging 1 - 34	
				Packaging 1 - 35	
				Packaging 1 - 36	
				QC 4 - 26	
				QC 4 - 28	
				QC 4 - 42	
				QC 4 - 58	
				QC 4 - 6	
				QC 4 - 69	
				QC 4 - 9	
				QC 4 - 46	
130 Packaging 3-1 - Stock - B4B	1 pcs	3/29/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
135 DC - 1 - B4B	1 pcs	3/29/19	0.00 0.00	DC - 1 - B4B	
				DC - 2 - B4B	
140 QC 21 - FG	1 pcs	3/29/19	0.00 0.00	QC 21 - FG - 21	
				QC 21 - FG - 70	
				QC 21 - SA - 53	

DAS
75
9-89

MB

08/09/2019

DAS
21
9-89

AUG 12 2019

DAS
21
9-89

AUG 12 2019

FG018

Part Op 100 - Packaging1-1 (Pick Kit)
 Descriptions: 110 - QC4 (QC4- 100% Inspect kits for completeness)
 130 - Package as per PPP D135-1027-103 Identify and Stock Location :
 135 - (Document Control) Photocopy blue file & type labels as per PPP D135-1027-103 CHG 001
 140 - QC21 (QC21- Final Inspection - Work Order Release)

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By _____ Lead hand / Supervisor _____ QC / QA Coordinator _____	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
		Other/Details: _____			

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN310C8	Nut	4 Ea (4 ea)	100-Packaging 1 - Pick Kit	5103998
D135-1027-143	MID HEIGHT FWD Crosstube Assembly	1 pcs (1 ea)	100-Packaging 1 - Pick Kit	5192782
D5416-1	Bushing	4 pcs (4 ea)	100-Packaging 1 - Pick Kit	51036072
D5417-1	Support Plate	4 pcs (4 ea)	100-Packaging 1 - Pick Kit	5033377
D5464-1	Washer	4 pcs (4 ea)	100-Packaging 1 - Pick Kit	5149145
MS21042-5	Nut	2 Ea (2 ea)	100-Packaging 1 - Pick Kit	5149144
MS21043-3	Nut	8 Ea (8 ea)	100-Packaging 1 - Pick Kit	5075171
MS21920-32	Clamp	13 Ea (13 ea)	100-Packaging 1 - Pick Kit	5137878.70
MS24665-306	Cotter Pin	8 Ea (8 ea)	100-Packaging 1 - Pick Kit	5132615
NAS1149C0363R	Washer	8 Ea (8 ea)	100-Packaging 1 - Pick Kit	5154686
NAS1149D0563J	Washer	8 Ea (8 ea)	100-Packaging 1 - Pick Kit	5072196
AN5-44A	Bolt	2 Ea (2 ea)	100-Packaging 1 - Pick Kit	5190502
D5415-1	Med Height Saddle	2 Ea (2 ea)	100-Packaging 1 - Pick Kit	5159900
D5677-1	Pin	2 pcs (2 ea)	100-Packaging 1 - Pick Kit	5198662
D5720-041		4x		

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Packaging 1 - Pick Kit	AN310C8	4	21	0
	AN5-44A	2	67	0
	D135-1027-143	1	0	0
	D5415-1	2	0	0
	D5416-1	4	40	0
	D5417-1	4	41	0
	D5464-1	4	32	0
	D5677-1	2	0	0
	MS21042-5	2	0	0
	MS21043-3	8	1,382	0
	MS21920-32	13	200	0
	MS24665-306	8	78	0
	NAS1149C0363R	8	645	0
	NAS1149D0563J	8	972	0

Part Specifications

Specifications could not be found.

Plex 2/11/19 11:42 AM dart.white.jesse

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Cross tube ☐ Eng. (Non-AW) ☐ Engineering ☐ Machining ☐ Small Fab ☐ Prod. Eng. Coord. ☐ Water Jet ☐ Large Fab ☐ Finishing ☐ Rec/Store/Packaging ☐ Supplier ☐ Quality ☐					
Date : _____		Sequence #: _____		QTY Affected : _____		MRB (QS1042)	
Description Work Order Deviation				Disposition			
				Completed By			
				Lead hand / Supervisor			
				QC / QA Coordinator			
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pull ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish					
Other/Details:							

5.0 PARTS LIST

For convenience, only the last three digits of the part number are listed on the top row of the table. The quantity of each component which is included in the D135-1027-101 Kit, for example, is as defined in the column labeled -101.

Qty -101	Qty -103	Qty -201	Qty -203	Part Number	Description
X				D135-1027-101	STD HEIGHT FWD CROSSTUBE INSTALLATION
	X			D135-1027-103	MID HEIGHT FWD CROSSTUBE INSTALLATION
		X		D135-1027-201	STD HEIGHT AFT CROSSTUBE INSTALLATION
			X	D135-1027-203	MID HEIGHT AFT CROSSTUBE INSTALLATION
1				D135-1027-141	STD HEIGHT FWD CROSSTUBE ASSY
	1			D135-1027-143	MID HEIGHT FWD CROSSTUBE ASSY
		1		D135-1027-241	STD HEIGHT AFT CROSSTUBE ASSY
			1	D135-1027-243	MID HEIGHT AFT CROSSTUBE ASSY
2	2	2	2	D5411-1 (1)	RUBBER BUSHING
2	2	2	2	D5412-041 (1)	CROSSTUBE CLAMP
2	2	2	2	D5413-1 (1)	CROSSTUBE SUPPORT
4	4	4	4	D5414-1 (1)	SUPPORT BOLT
	2		2	D5415-1	MID HEIGHT SADDLE
2		2		D5415-3	STANDARD HEIGHT SADDLE
4	4	4	4	D5416-1	BUSHING
4	4	4	4	D5417-1	SUPPORT PLATE
4	4	4	4	D5464-1	WASHER
		2	2	D5541-041	GROUND HANDLING PIN
		2	2	D5541-3	GROUND HANDLING NUT
			4	D5541-5	GROUND HANDLING WASHER
2	2			D5677-1	PIN
4	4	4	4	D5720-041	CLAMP
4	4	4	4	AN310C8	NUT, CASTELLATED
2	2	2	2	AN5-44A	BOLT
2	2	2	2	MS21042-5	NUT, SELF LOCKING
8*	8*	12*	12*	MS21043-3	NUT, SELF LOCKING
8*	8*	8*	8*	MS24665-306	COTTER PIN
8*	8*	12*	12*	NAS1149C0363R	WASHER
8*	8*	8*	8*	NAS1149D0563J	WASHER

* Additional hardware provided.

(1) Pre-assembled on D135-1027-141/-143/-241/-243 Crosstube Assemblies.

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Revision: D

Date: 19.03.15

Change Record

PAGE 1 OF 1

Part Number: D135-1027-103

Description: MID HEIGHT FWD CROSSTUBE INSTALLATION

[illegible]